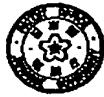


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(54) NARROW GROOVE WELDING METHOD

(57) Abstract:

PURPOSE: To prevent the generation of feed resistance and to permit stable welding by feeding a welding wire to the parts to be welded at a constant speed with the 1st wire feed motor, and feeding the wire to the 1st wire feed motor at the speed equal to or higher than that of the 1st wire feed motor with the 2nd wire feed motor.

CONSTITUTION: Narrow groove welding is executed by using plural pieces, for example, 2 pieces of wire feed motors. At this time, the 1st wire feed motor 4 feeds a welding wire 1 to parts 3 to be welded at a constant speed and the 2nd wire feed motor 2 feeds the wire 1 to the motor 4 at the wire feed speed equal to or higher than that of the motor 4 in order to provide curved bends to the wire 1. If the wire 1 is bent in this way, no feed resistance is generated.

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